

Work Order ID 62035

Wednesday, September 15, 2010 10:13:16 A



Page 1

Item ID: D206-559-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 9/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 1.00



Customer:

Reference: ECN 10-613

Approvals: Process Plan: mf

Date: 9-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-559	J -PRELIM								

200

0.00



Packaging

Memo

0.00

PULL FROM STOCK D206-559-023

B 39081 X 1

REMOVE AN4-15A BLOTS AND REPLACE WITH AN4-20A

MEL WILL MAKE AN ADJ

UPDATE PAPERWORK AND LABELS TO CHANGE 7

210

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Scalorio

12/9/10 DSP

(70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 9/15/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 1.00

Customer:

Reference: ECN 10-613

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

Identify as per dwg & Stock Location: 12

0.00

Reub

9/16

9

10



Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/17

MF 10-9-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




NOTE: Date & initial all entries

Wednesday, September 15, 2010 10:13:15 AM



Required Qty: 1.00

Comments: IPP Rev: E 04.02.17 Tolerance added to Step 3 KJ/JLM
IPP Rev: F 07-01-02 Was K10006 JLM
IPP Rev:G 08-09-19 Added step 2 JLM Verified By:EC
IPP Rev:H New Manufacturing Method 08-10-29 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-15A 		Purchased	No				Each	323.0000	12	-12		10/9/16	
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST338				112					
				ST358				211					
				112905				12					
				114784				21					
				115108				78					
				115371				100					
AN4-20A 		Purchased	No				Each	678.0000	12			10/9/16	
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST359				678					
				104016				662					
				16895				16					
D206-559-023 		Manufactured	No				Each	6.0000	1			10/9/16	
Bearpaw													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG012				6					
				39081				1					
				41734				5					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries





REFERENCE ONLY

5.0 PARTS LIST (D206-559 REV. K) 32.7 PARTS LIST (ICA-D205-559 REV. 2)

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 10.06.30
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9527 SHEET 2 OF 2
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DE APPR.		BOLT CHANGE NTS
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